

Work Order ID 100642

Thursday, April 25, 2013 8:05:33 AM

100642

Ship Asap Page 1

Item ID: D4820-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: FPC Clip Profile

Start Date: 4/25/2013 Start Qty: 16.00

16

Cust Item ID:

Required Date: 4/29/2013 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan: *mf*Date: *3-4-25*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4820

A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4820

Dwg Rev: *A*Prog Rev: *A*

2-Deburr as required

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

DAS
05
9-83 13-04-25DAS
05
9-83 13-04-25

Work Order ID 100642

Thursday, April 25, 2013 8:05:33 AM

100642

Page 2

Item ID: D4820-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: FPC Clip Profile

Start Date: 4/25/2013 Start Qty: 16.00

16

Cust Item ID:

Required Date: 4/29/2013 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
27
13.4.25

16

140

NC BRAKE

0.00

140

Brake NC

Memo

0.00

Brake NC

Bend and c/sink hole as per Dwg D4820

16

DAS
13/04/26

13/04/26

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

DAS
27
13.4.26

16

Work Order ID 100642

Thursday, April 25, 2013 8:05:33 AM

100642

Page 3

Item ID: D4820-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: FPC Clip Profile

Start Date: 4/25/2013 Start Qty: 16.00

16

Cust Item ID:

Required Date: 4/29/2013 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

180

Identify as per dwg & Stock Location: GA

0.00

180

Packaging

Memo

0.00

Packaging

16x

13/5/13

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

13/5/13

B-05-3

Picklist Print

Thursday, April 25, 2013 8:05:33 AM

Page 1

Work Order ID: 100642

Parent Item: D4820-3

Parent Item Name: FPC Clip Profile

Start Date: 4/25/2013

Required Date: 4/29/2013

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A NEW ISSUE 13-04-15 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No				sf	286.5214		<u>0.3368421</u>		13.04.25	

Location

MAT020

Loc Qty

286.5213688

Loc Code

122245

0.1713688

123136

140.8

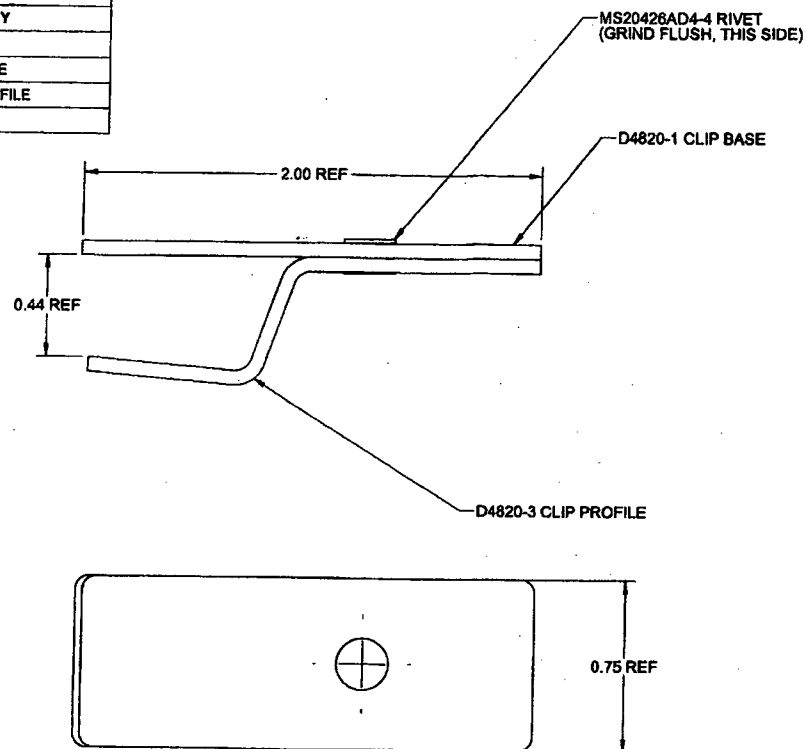
124428

29

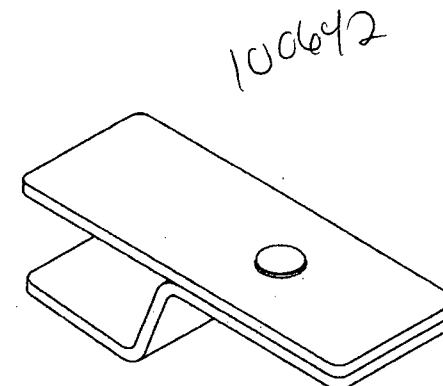
124572

116.55

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4820-041	CLIP ASSY
1	1	D4820-1	CLIP BASE
2	1	D4820-3	CLIP PROFILE
3	1	MS20426AD4-4	RIVET



D4820-041 CLIP ASSY

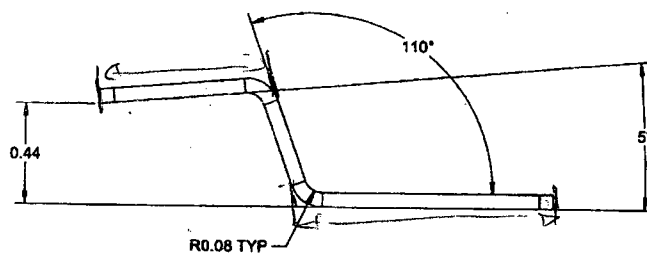
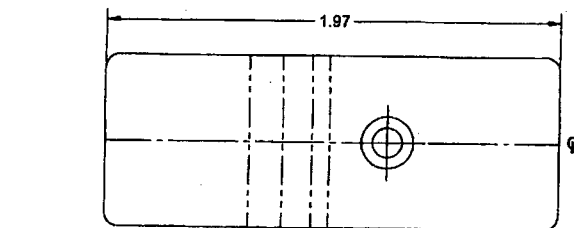


RELEASED
2013-04-18
WJD

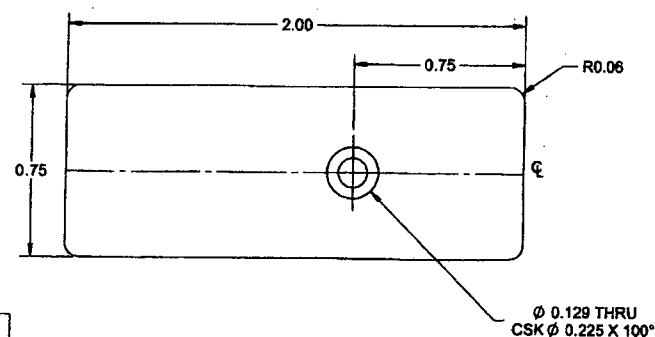
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4820-041" USING FINE POINT PERMANENT MARKER, QSI 044, METHOD 6.1
- 7) WEIGHT: 0.06 lbs

A	NEW ISSUE	DB	13.04.10
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	<i>DB</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>WJD</i>	D4820	SHEET 1 OF 2
APPROVED	<i>WJD</i>	TITLE	SCALE
DE APPR.	<i>WJD</i>	CLIP ASSY	NTS
DATE	13.04.10	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

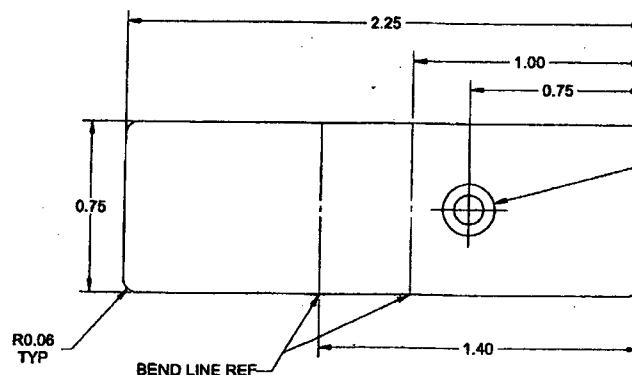


D4820-3 CLIP PROFILE
(MAKE FROM D4820-3F)



0.083 REF

D4820-1 CLIP BASE



D4820-3F FLAT PATTERN

Ø 0.129 THRU
CSK Ø 0.225 X 100°

RELEASED
2013-04-18

NOTES:

- 1) MATERIAL: AISI 304/316 SS, 0.063" THICK AS PER DART SPEC M304S16GA1P OR MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4820-1: 0.03 lbs, D4820-3: 0.03lbs

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.		D4820	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CLIP ASSY	NTS
DATE	13.04.10	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

